

Date: Tuesday, 15/07/2008 9:13:13 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET		
Job Number	40467			Part Number	: D3211		
Estimate Number	10710			Drawing Number	: D3211 REV A1		
P.O. Number				Project Number	: N/A		
This Issue	15/07/2008	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	: 21/07/2008 Qty: 10 Um: Each		
Previous Run	39743						
Written By							
Checked & Approved By	<u>JUL 08.15.08</u>						
Comment	Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 1.4753 sf(s)/Unit Total : 14.7525 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3211-1 Batch: <u>108415</u> FB 8-8-11	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3211 Dwg Rev: <u>A1</u> FB 8-8-11 Prog Rev: <u>A1</u>	
		2-Deburr if necessary FB 8-8-11	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>FB 8-8-11</u>	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK <u>S 08/08/4 X10</u>	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>Done at step 2.2 8/8/11</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 40467		Part Number: D32111
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
		PTO
Comment: NC BRAKE Bend D3211-1 Stack as per Dwg D3211		
7.0	QC5	INSPECT WORK TO CURRENT STEP
		08/09/19 ③
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		08/09/20 ③X
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	POWDER COATING	POWDER COATING
		M-1 08/09/22 ③X
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
START TIME:	10:30	
OVEN TEMPERATURE:	320°	
FINISH TIME:	11:00	
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		M-1 08/09/24 X3
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock		
Location:	ST212	
12.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/09/25 X
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
		08/09/25 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: N/A Fault Category: ~~Prod Fab Ass~~ ^{ined & small} NCR: Yes No DQA: S Date: 08/09/19
 Eng/Dsg. QA: N/C Closed: P Date: 08/09/19

NCR: 40467		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/19	6	7 piece were scrap piece broke at the bend	<u>J</u> <u>08/09/19</u>	Scrap & destroy No replace	83 08/09/19	<u>J</u> <u>08-09-19</u>	<u>J</u> <u>08/09/19</u>	<u>J</u> <u>08-09-19</u>
		R.C material was Drawing wasn't charge for 45° Took die 3/16 until 118 Grain ran along the bend.	<u>J</u> <u>08/09/19</u>	Drawing is being updated.	<u>J</u> <u>08-09-19</u>	<u>J</u> <u>08-09-19</u>	<u>J</u> <u>08/09/19</u>	<u>J</u> <u>08-09-19</u>
			<u>J</u> <u>08/09/19</u>		<u>J</u> <u>08-09-19</u>	<u>J</u> <u>08/09/19</u>	<u>J</u> <u>08/09/19</u>	<u>J</u> <u>08-09-19</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	404607
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HR</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-8-11	Date:	08/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	FF

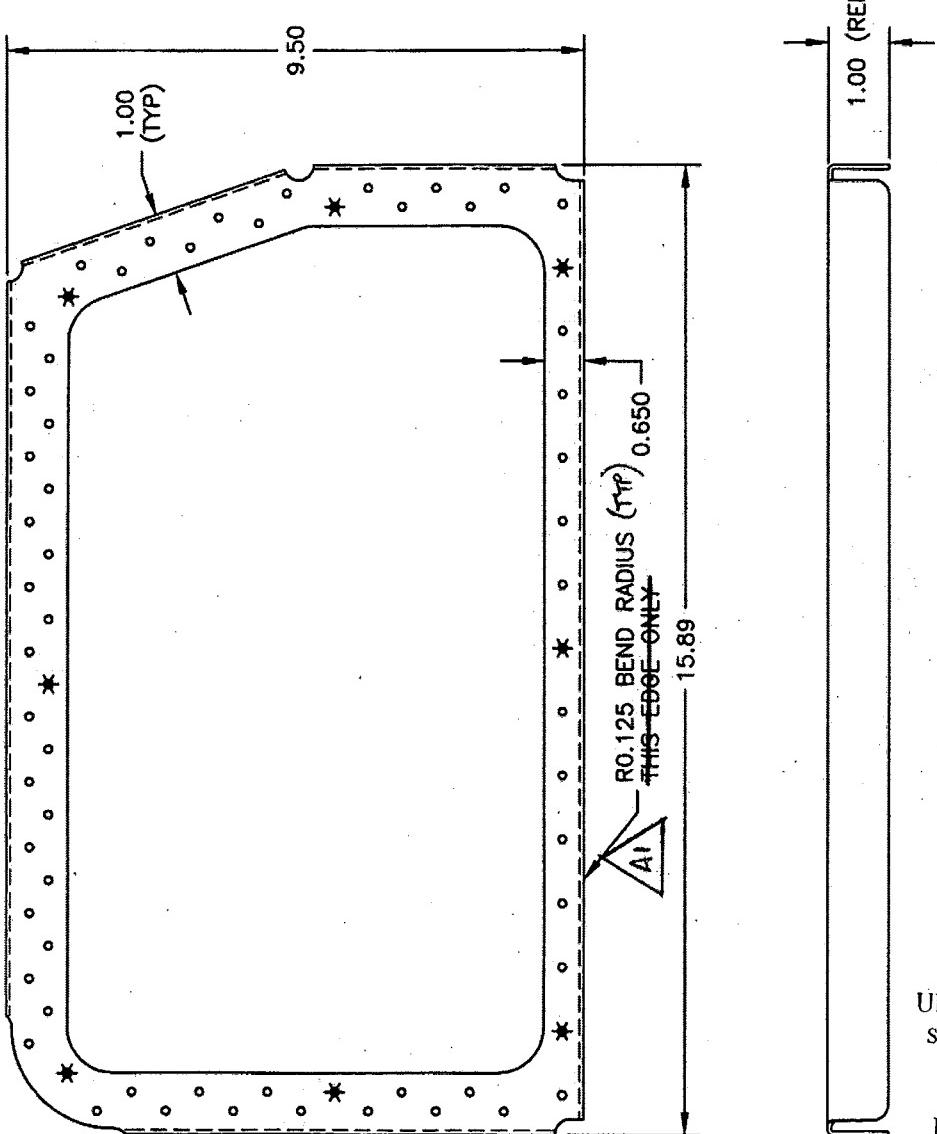
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3211	SHEET 1 OF 2
DATE		TITLE	SCALE
03.09.03		BRACKET	1:5
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL BEND RADIUS TO R0.125	

RELEASED

03.09.03

D3211-1 BRACKET
 MACHINE PER DRAWING FILE "D3211-A2.DWG"
 CHECK PER TEMPLATE D3211-1T1
 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
 USE MINIMUM BEND RADIUS OF ϕ 488⁺, EXCEPT WHERE INDICATED ϕ .125⁺
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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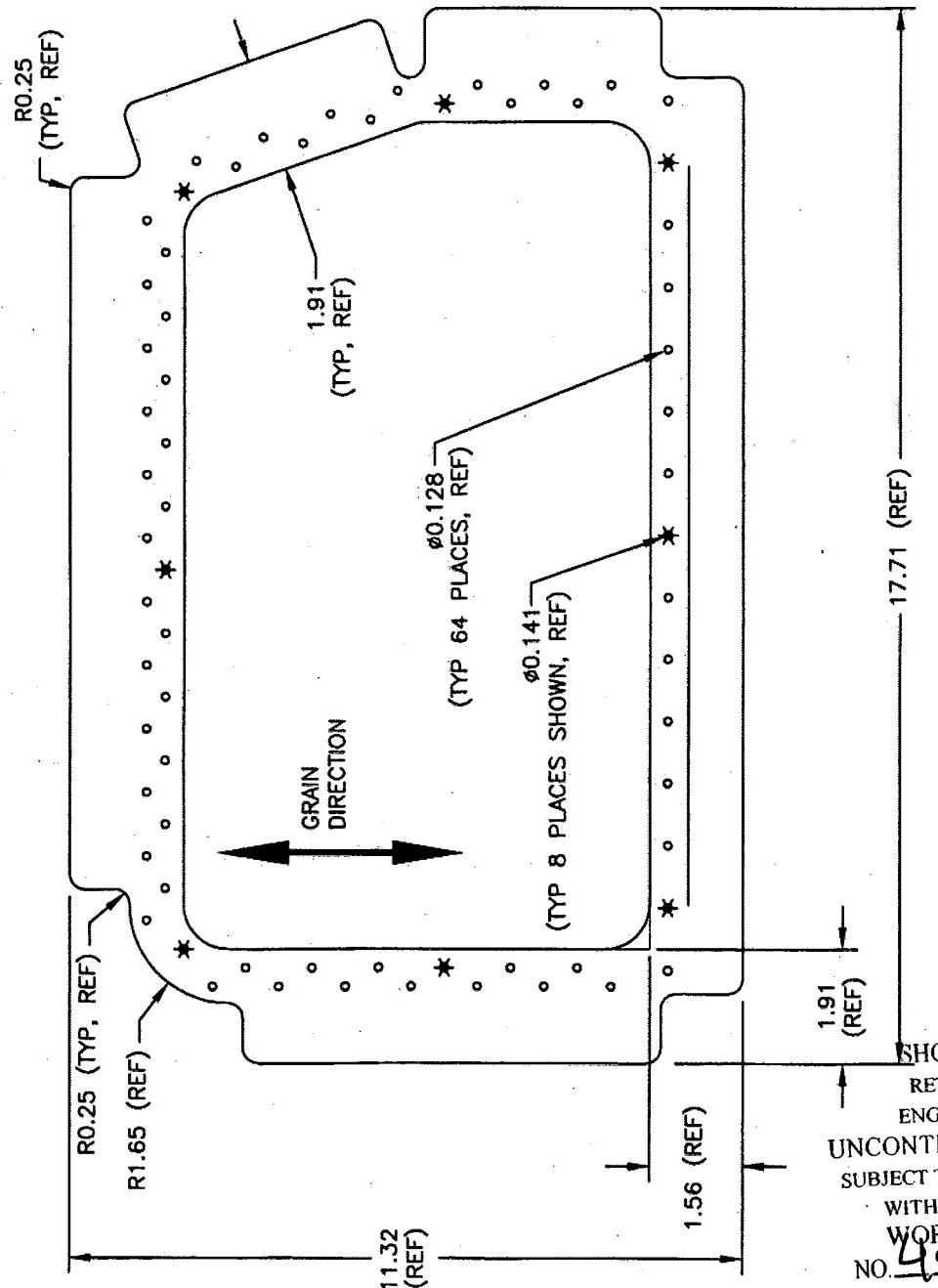
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	03.09.03	D3211	SHEET 2 OF 2

RELEASED
03.09.03

D3211-1 FLAT PATTERN



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